

Work Order ID 54765

December 21, 2009 9:06:56 AM



Page 1

Item ID: D2565-103

Accept



Setup Start



Revision ID:

Item Name: Strut

Stop



Start Date: 12/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00



NC BRAKE

Brake NC

Memo

0.00

Brake NC

Punch to length as per Dwg D2565 using DT8313

SP 10/01/21

6 8

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

1-Drill hole open to .316 Ø as per Dwg D2565 (one end only) 12-Deburr

7m-h

6X 10/01/26

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> Sidelb7

46

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Work Order ID 54765

December 21, 2009 9:06:57 AM



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Item ID: D2565-103

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 12/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

1:00pm

OVEN TEMPERATURE:

1:30pm FINISH TIME:

400°F

M113170

=> Jel

10-01-27

X6 Ø

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

=> m-1 10/01/27 (6X)

150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

270

10-1-27

(6X) S1

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 54765

December 21, 2009 9:06:57 AM



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Item ID: D2565-103

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 12/21/09 Start Qty: 6.00



Cust Item ID:

Required Date: 1/04/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/28
ME 10-1-27

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

December 21, 2009 9:06:56 AM

Page 1
1

Work Order ID: 54765



Parent Item: D2565-103



Parent Item Name: Strut

Start Date: 12/21/09

Required Date: 1/04/10

Comments:

Start Qty: 6.00

Required Qty: 6.00

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Remaining Qty To Pick | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|--------------------------|---------------|----------------|--------|
| M304TR0.750W.049 | | Purchased | No | | | 100 | f | 326.9924 | 9.5842 | | | |



304 RD Tube .750 x .049W



| <u>Warehouse</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|------------------|----------------|-----------------|
| <u>Location</u> | | |
| Main Warehouse | | |
| MAT | 326.9924 | |
| 107518 | 2.77 | |
| 108498 | 0 | |
| 109314 | 8.5 | |
| 110113 | 0.73 | |
| 110271 | 0.03 | |
| 111096 | 9 | |
| 111457 | 11.43 | |
| 112652 | 85.89 | |
| 112800 | 208.6424 | |

11 20 10/1/21 (6)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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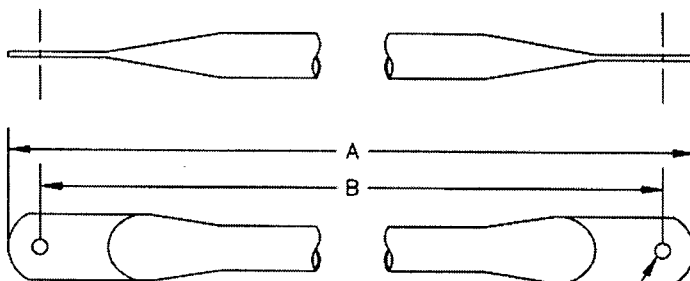
NOTE: Date & initial all entries



| | | | |
|----------------------------|-----------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D2565 | REV. E SHEET 1 OF 1 |
| DATE 04.05.05 | | TITLE STRUT SCALE 1:3 | |
| A | 96.05.03 | NEW ISSUE | |
| B | 97.03.15 | CORRECT D2565-111 DIM. A | |
| C | 98.10.05 | UPDATED MATERIAL NOTE (TSR A603) | |
| D | 02.06.05 | ADD -3XX PARTS; ADD FINISH | |
| E | 04.05.05 | ADD D2565-401-411; RMV ANGLE D | |

RELEASED
04.05.05 *[Signature]*

wo 54765



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

| PART # | A | B | DIA C |
|-----------|-------|-------|-------|
| D2565-101 | 20.52 | 19.72 | 0.316 |
| D2565-103 | 18.21 | 17.41 | 0.316 |
| D2565-105 | 20.19 | 19.39 | 0.316 |
| D2565-107 | 13.43 | 12.63 | — |
| D2565-109 | 12.31 | 11.51 | — |
| D2565-111 | 13.65 | 12.85 | — |
| D2565-201 | 22.79 | 22.00 | 0.316 |
| D2565-203 | 20.75 | 19.95 | 0.316 |
| D2565-205 | 21.22 | 20.42 | 0.316 |
| D2565-207 | 16.07 | 15.27 | — |
| D2565-209 | 15.16 | 14.36 | — |
| D2565-211 | 14.14 | 13.34 | — |
| D2565-301 | 27.03 | 26.23 | 0.316 |
| D2565-303 | 25.34 | 24.54 | 0.316 |
| D2565-305 | 23.73 | 22.93 | 0.316 |
| D2565-307 | 20.86 | 20.06 | — |
| D2565-309 | 20.17 | 19.37 | — |
| D2565-311 | 16.30 | 15.50 | — |
| D2565-401 | 18.29 | 17.49 | 0.316 |
| D2565-403 | 15.64 | 14.84 | 0.316 |
| D2565-405 | 19.45 | 18.65 | 0.316 |
| D2565-407 | 10.79 | 9.99 | — |
| D2565-409 | 9.34 | 8.54 | — |
| D2565-411 | 13.81 | 13.01 | — |

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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